

Work Order ID 85111

Friday, June 01, 2012 4:05:00 PM

85111

Page 1

Item ID: PB67-43001-15

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLF*

Date: *12-06-14*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-15	Rev C								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding								
	2- assemble parts and weld as per dwg								
	3- grind weld flush in area of PB67-43001-249 only								
	4- install helicol insert as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

1 0
1 0
12.06.15
FF 12-06-18

1 0
12.06.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME:
12:30 OVEN TEMPERATURE: 3200 F FINISH
TIME: 11:20

1 MG 12-6-19

ML
12/06/20

M18144

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

PICK Kit

1 x Ø All n/06/24

1K

SP 12-6-21

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support2- assemble as per dwg

1 Ø

Ac 12.06.25

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1

n/12.06.25

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/6/2012

12/6/26

ME
12-06-25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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2

Work Order ID: 85111

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-71 PB67-43001-71		Manufactured	No				Each	1.0000		1		12.06.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437A		1				1			
				41512		1							
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	7.0000	1	1		12.06.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		7							
				52480		7							
PB67-43001-253 Gusset		Manufactured	No			100	Each	0.0000	1	1		12.06.15	
PB67-43001-254 Gusset		Manufactured	No			100	Each	20.0000	1	1		12.06.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		20							
				52481		20							
PB67-43001-257 Inner Tube		Manufactured	No			100	Each	1.0000	1	1		12.06.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		1							
				62124		1							
MS124780 HELICAL INSERT		Purchased	No			180	Each	86.0000	1	1		12.06.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		86							
				111064		86							

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Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased No

180 Each 126.0000 8

Screw

m1220278p

Location

Loc Qty

Loc Code

GA 100
120449 100
ST291 26
120120 26

NAS1149D0316J

Purchased No

180 Each 0.0000 8

Washer

m196008p

NAS1149D0363J

Purchased No

180 Each 2,183.0000 8

Washer

Location

Loc Qty

Loc Code

ST298 2183
117601 61
118077 1
118612 18
119537 33
120142 13
120308 17
120644 86
121243 494
121524 1460

PB67-43001-73

Manufactured No

180 Each 7.0000 1

20 Degree Cover Plate

Location

Loc Qty

Loc Code

ST437A 7
53305 7

PB67-43001-83

Manufactured No

180 Each 11.0000 1

PB67-43001-83

Location

Loc Qty

Loc Code

ST444 11
53240 11

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Shop Packet Print

Page 2

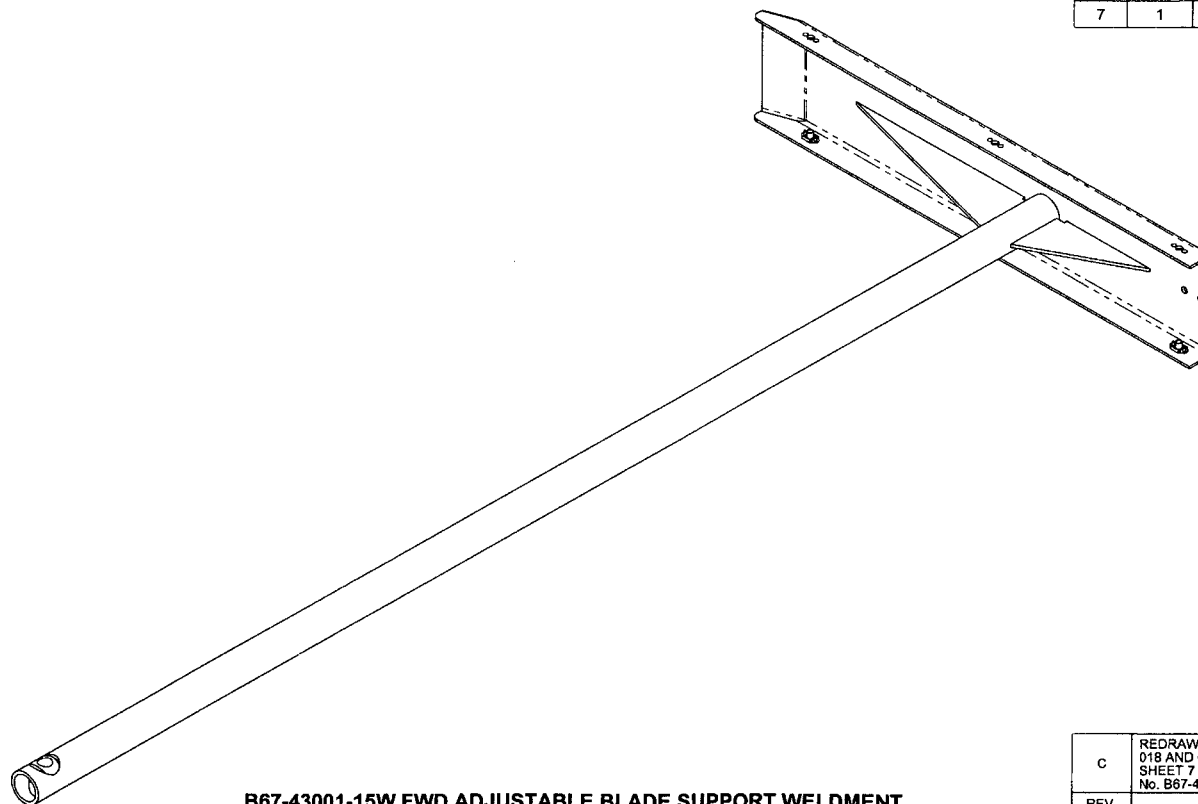
W/O:		WORK ORDER CHANGES					
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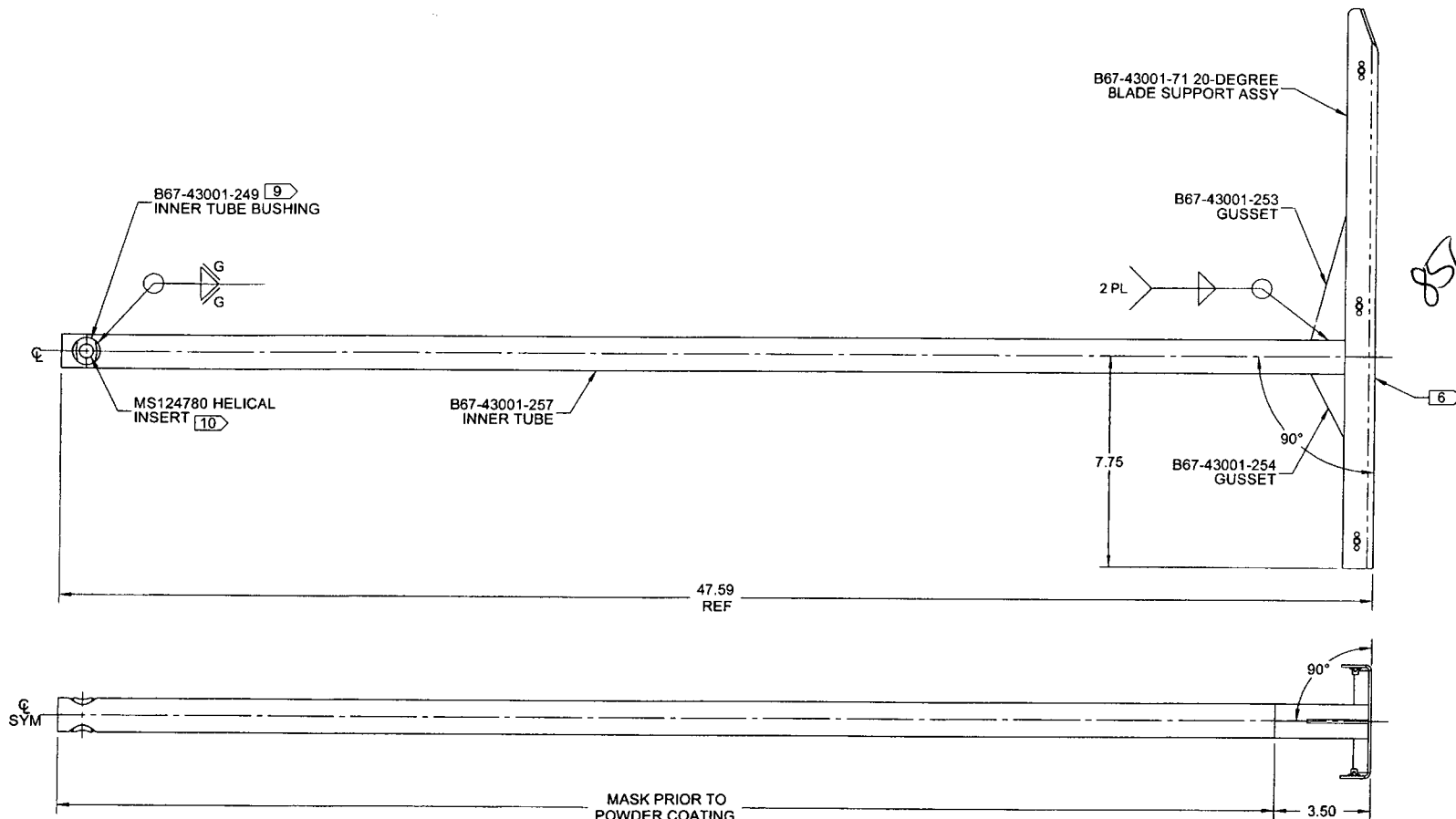
NOTE: Date & initial all entries



ITEM	QTY -15W	P/N	DESCRIPTION
1	X	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-257	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-06
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	[Signature]	DRAWING NO. B67-43001-15W REV. C		
CHECKED	[Signature]	SHEET 1 OF 2		
MFG. APPR.	[Signature]	TITLE		
APPROVED	[Signature]	FWD ADJUSTABLE BLADE SUPPORT WELDMENT NTS		
DE APPR.	N/A	SCALE		
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-15W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.35 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-15W	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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